

Work Order ID 89759

89759

Page 1

Wednesday, September 05, 2012 10:30:40 A

Item ID: 647.0114

Revision ID:

Item Name: Clip

Start Date: 9/5/2012 Start Qty: 20.00

Required Date: 9/28/2012 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date: 12-09-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.0100	A								

110

0.00

110

Waterjet

FLOW CNC Waterjet

2024.063

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

20 0 Jm 12-9-16

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

20 0 Jm 12-9-16

Work Order ID 89759

89759

Page 2

Wednesday, September 05, 2012 10:30:40 A

Item ID: 647.0114

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clip

Start Date: 9/5/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/28/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00				20			
Quality Control									
140	Form as per dwg	0.00							
140									
Brake NC	Memo	0.00				10			SB 13/09/14
Brake NC									P10
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00				10			
Quality Control									

DAS
27
9-89
B916

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AWL Date: 13/10/23QA Closed: AWL Date: 13/10/23

Work Order: <u>89759</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS					
Part No. <u>647.0114</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. <u>13-3151</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input checked="" type="checkbox"/>	Quality <input type="checkbox"/>		
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	<u>13/09/16</u>	<u>130</u>	<u>10</u>	scrap other 10 flzt p>flvus Now ordered at GFI unable to make @ Dart	<u>W</u> <u>13/09/16</u>	\$22.92	<u>AWL</u> <u>13/09/16</u>	DAS 27 9-89 <u>13 9 16</u>	<u>S</u> <u>13/10/21</u>
Equip/Tooling <input checked="" type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

PC Tooling

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Weld
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Wrong Stock Pulled
			<input type="checkbox"/> Other

Work Order ID 89759***89759***

Page 3

Wednesday, September 05, 2012 10:30:40 A

Item ID: 647.0114

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clip

Start Date: 9/5/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/28/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
160									
Outsource4	Memo	0.00							
Outsource process - Anodize	HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)								
170	Receive & Inspect for Damage & Mat'l Certs	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

131018

P13/14/18 (11)

11

89759

Wednesday, September 05, 2012 10:30:41 A

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 9/5/2012 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 9/28/2012 **Req'd Qty:** 20.00

20

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

190

0.00

190

0.00

SprayPaint

Memo

Spray Painting

PRIME LAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)

BATCH: 121022

200

QC14- Inspect Spray Paint

0.00

200

0.00

QC

Memo

Quality Control

210

Identify as per dwg & Stock Location: ST535 0.00

0.00

210

0.00

Packaging

Memo

Packaging

DAS
33
9-R9

13-10-18

Work Order ID 89759***89759***

Page 5

Wednesday, September 05, 2012 10:30:41 A

Item ID: 647.0114

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clip

Start Date: 9/5/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/28/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

[Handwritten signature] / *[Handwritten signature]* 13-10-21

13-10-21

Picklist Print

Page 1

Wednesday, September 05, 2012 10:30:45 AM

Work Order ID: 89759

89759

Parent Item: 647.0114

647 0114

Parent Item Name: Clip

Start Date: 9/5/2012

Required Date: 9/28/2012

Start Qty: 20.00

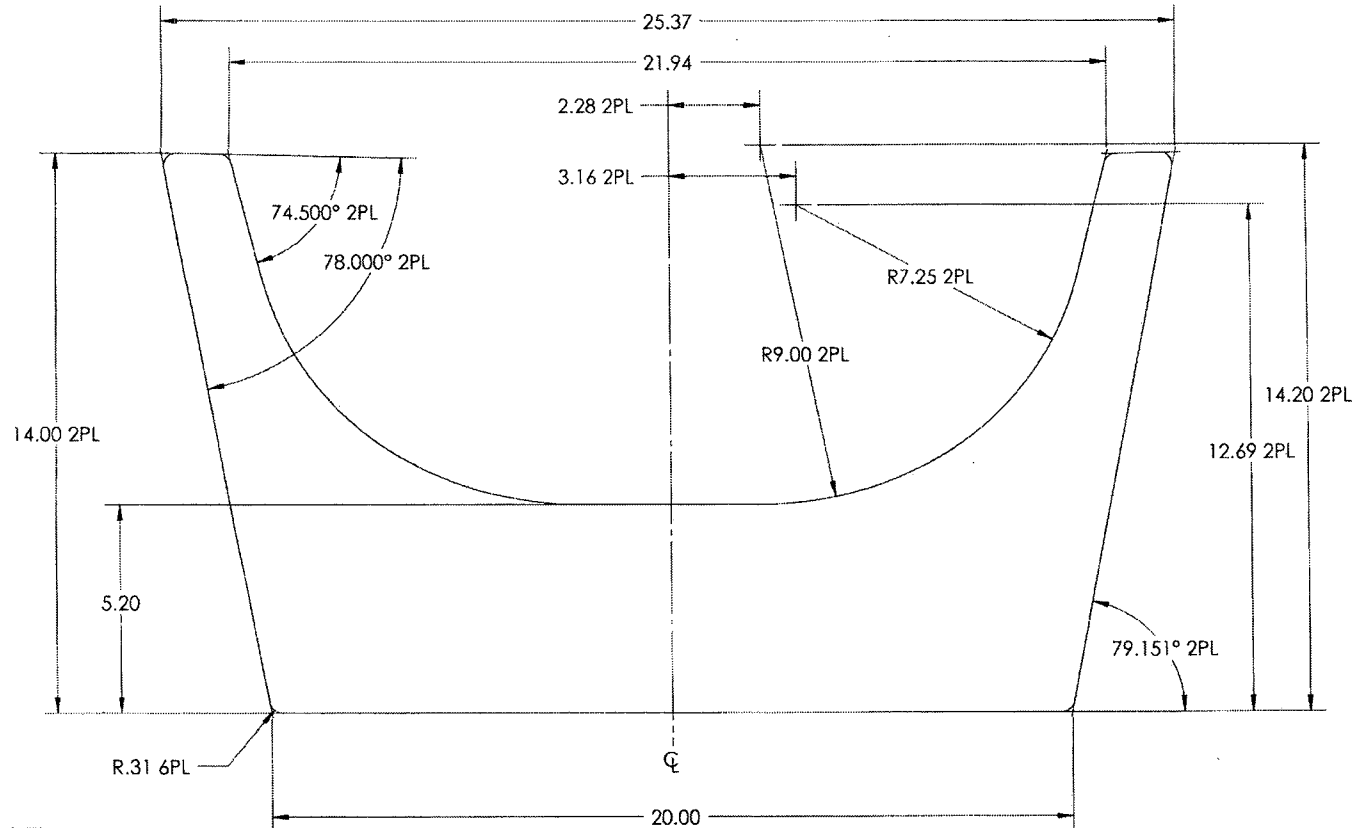
Required Qty: 20.00

Comments: IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	136.5200	0.0556	1170526 112			
									**				Jm 12-9-16
M2024T3S 063													
2024-T3 .063 sheet													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			MAT022		136.52								
			119916		67.1								
			121197		69.42				<u>121197</u>				

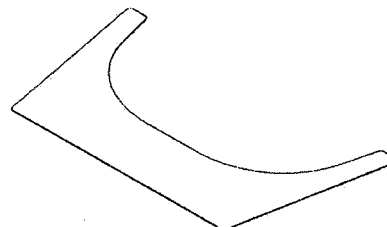
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REV	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION: PER		INTC
2	INITIAL RELEASE	05/08/06	P. BRAYO
3	ENDORSED DATE: ECH 02/02/02, 02/04/02, 02/06/02	04/28/11	P. BRAYO



NOTES:

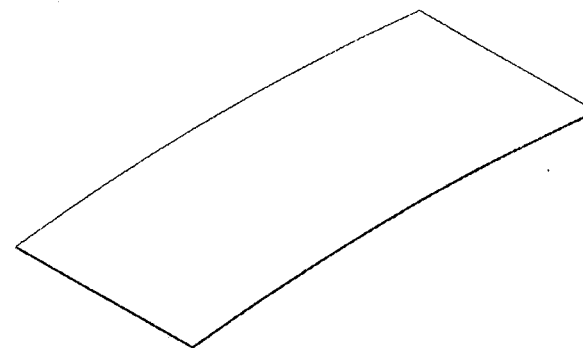
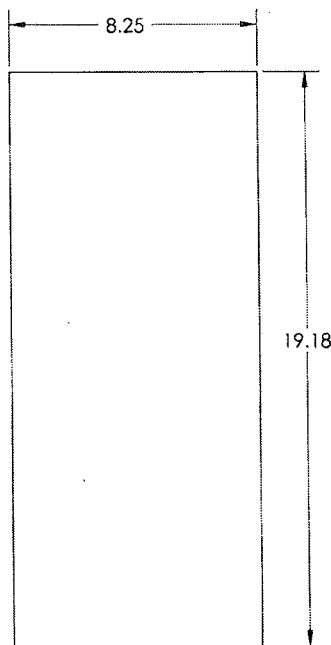
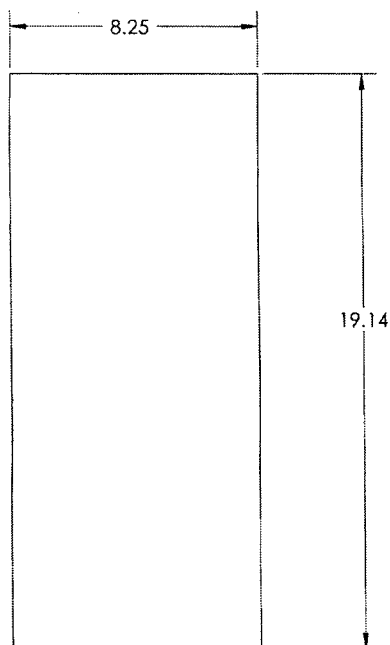
- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.



647.0110

		647.0116	DOUBLER	△	△
		647.0115	CLIP	△	△
		647.0114	CLIP	△	△
		647.0113	STRUT DOUBLER	△	△
		647.0112	STRUT BRACKET	△	△
		647.0111	PANEL	△	△
		647.0110	ROOF DOUBLER	△	△
	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY			PARTS LIST		
NEXT ASSY (S)			APICAL INDUSTRIES		
646.9500			2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300		
ORIGINAL DATE INITIALS DRAWN BY P. POSHET P. BRAVO REVIEWED APPROVAL P. BRAVO DATE 05-25-95 CONTACT INFO: UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES °			SHEETMETAL		
			SIZE C/GS 20X12		QTY 6
			SCALE NONE		REV A
			647.0100		1 OF 6
			SHIPPT		

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647.0111

89159

FLAT PATTERN



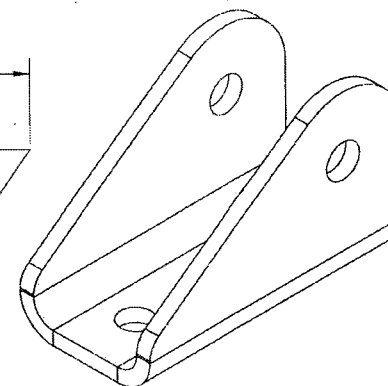
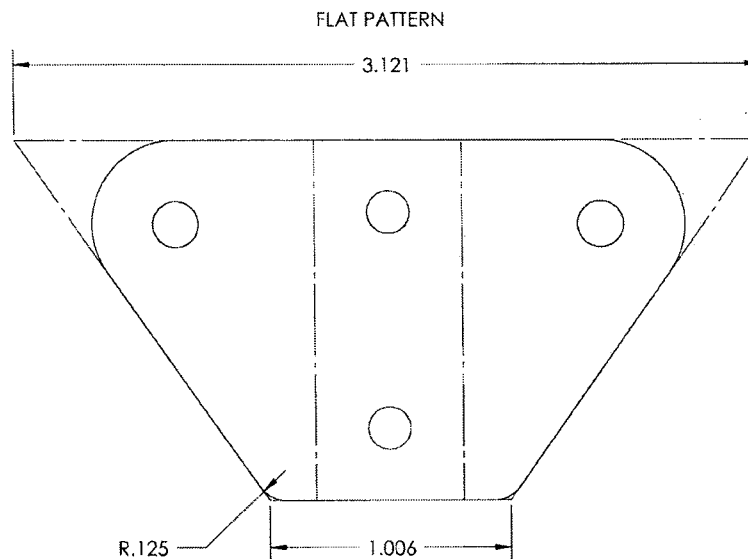
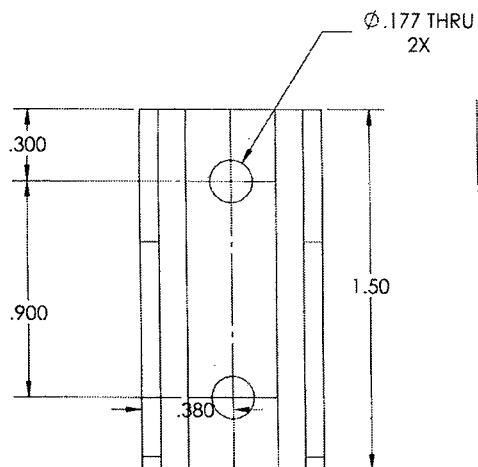
.063

R83.40

ORIGINAL DATE 12-28-09		APICAL INDUSTRIES	
DRAWN BY C. HICKER		2608 TEMPLE HEIGHTS DR.	
P. POS. NO. P. DRAWG.		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. DRAWG.		SHEETMETAL	
C. HICKER CT. NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	CAGE CODE 071126
		DWG. NO. 647.0100	REV. A
		SCALE NONE	SHEET 2 OF 6

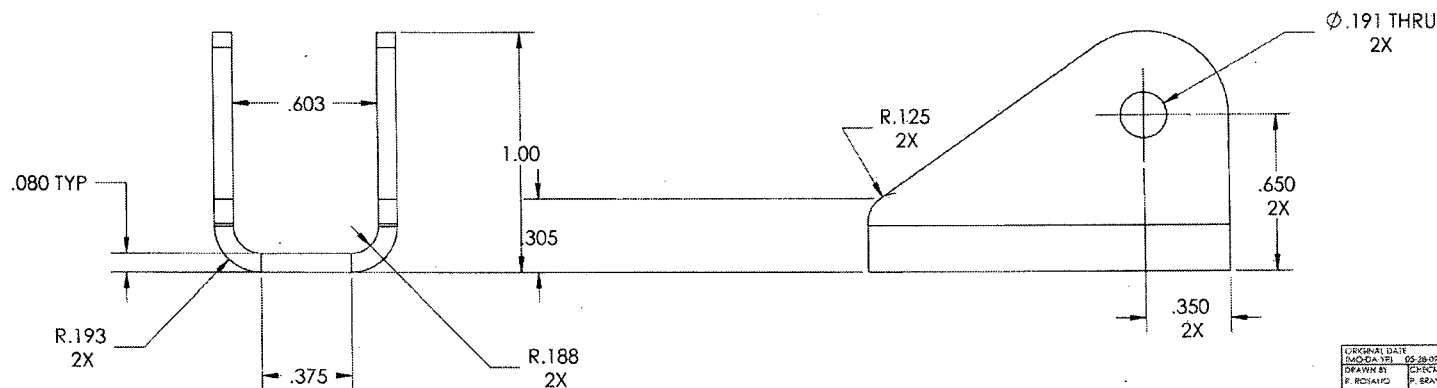
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REVISIONS		DATE	APPROVED
REV.	DESCRIPTION		



647.0112

89759



ORIGINAL DATE: 05-28-07
 DRAWN BY: CHICREP
 P. ROSARIO P. BRAVO
 DRAWING APPROVAL:
 P. BRAVO
 CONTRACT NO.

UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES
 TOLERANCES ARE:
 1 PLACE DECIMALS ±.01
 2 PLACE DECIMALS ±.005
 ANGLES ±.5°

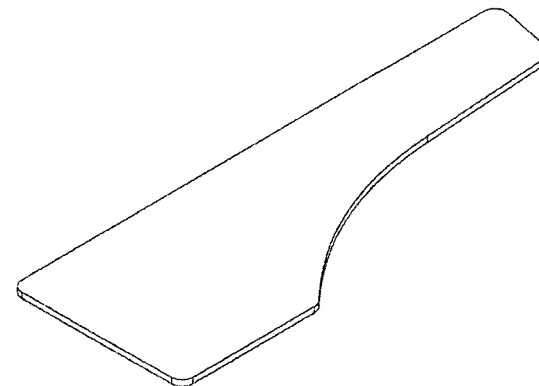
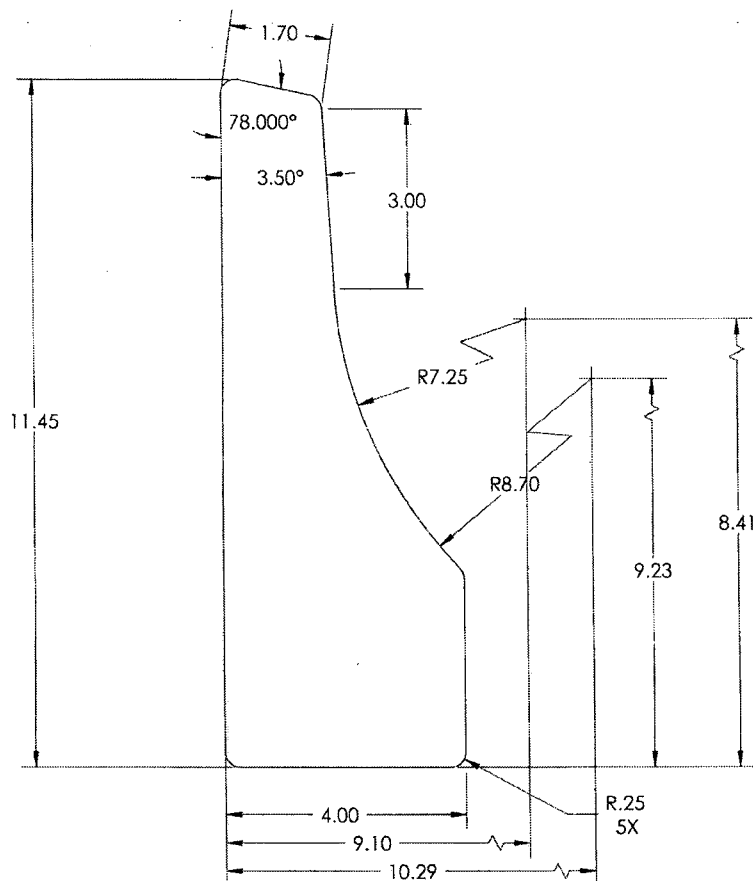
APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760)724-5300

SHEETMETAL

SIZE: LARGE CODE DWD. NO. 647.0100
 B: 07M26
 SCALE: NONE
 SHEET 3 OF 6

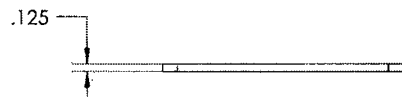
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0113

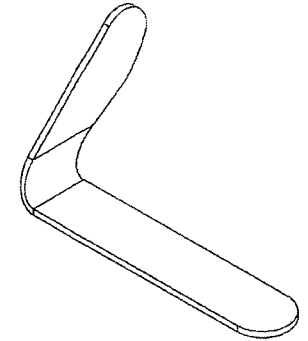
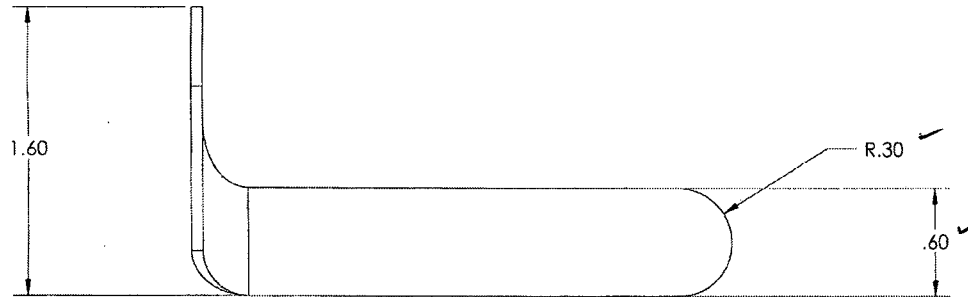
89759



ORIGINAL DATE Dwg. No. 101		DATE	
DRAWN BY P. ROSAHO	CHECKED P. ROSAHO	APICAL INDUSTRIES	
DRAWING APPROVAL P. ROSAHO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		DATE B 07/22/16	REV. A
SCALE NONE		DWG. NO. 647.010J	SHEET 4 OF 6

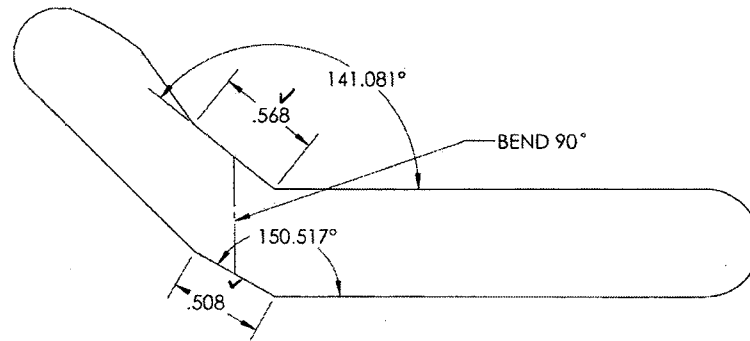
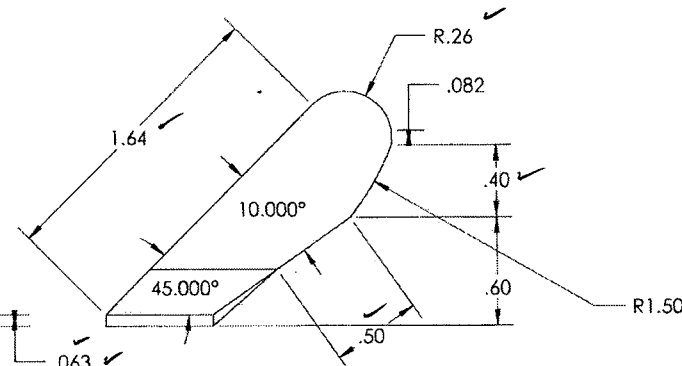
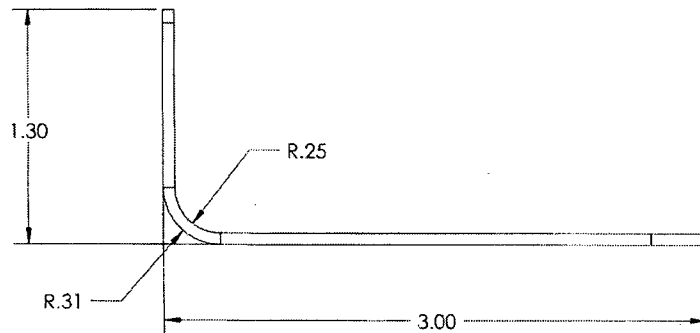
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0114 SHOWN
647.0115 OPPOSITE

89759
~~89759~~

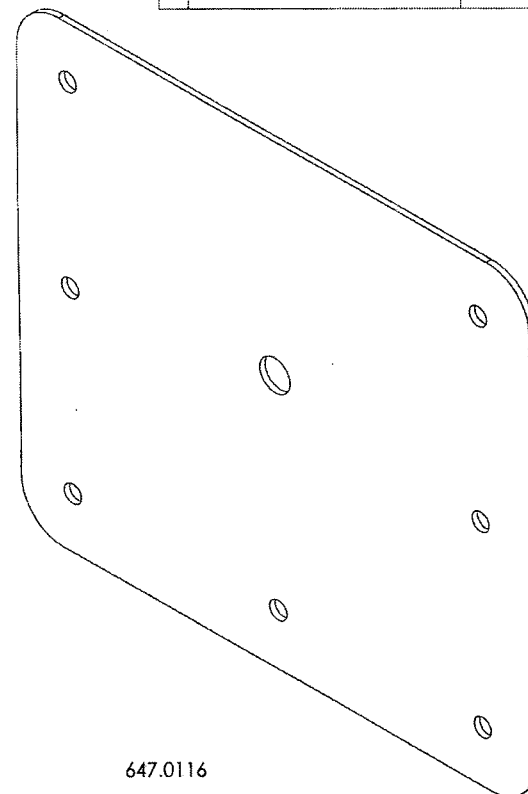
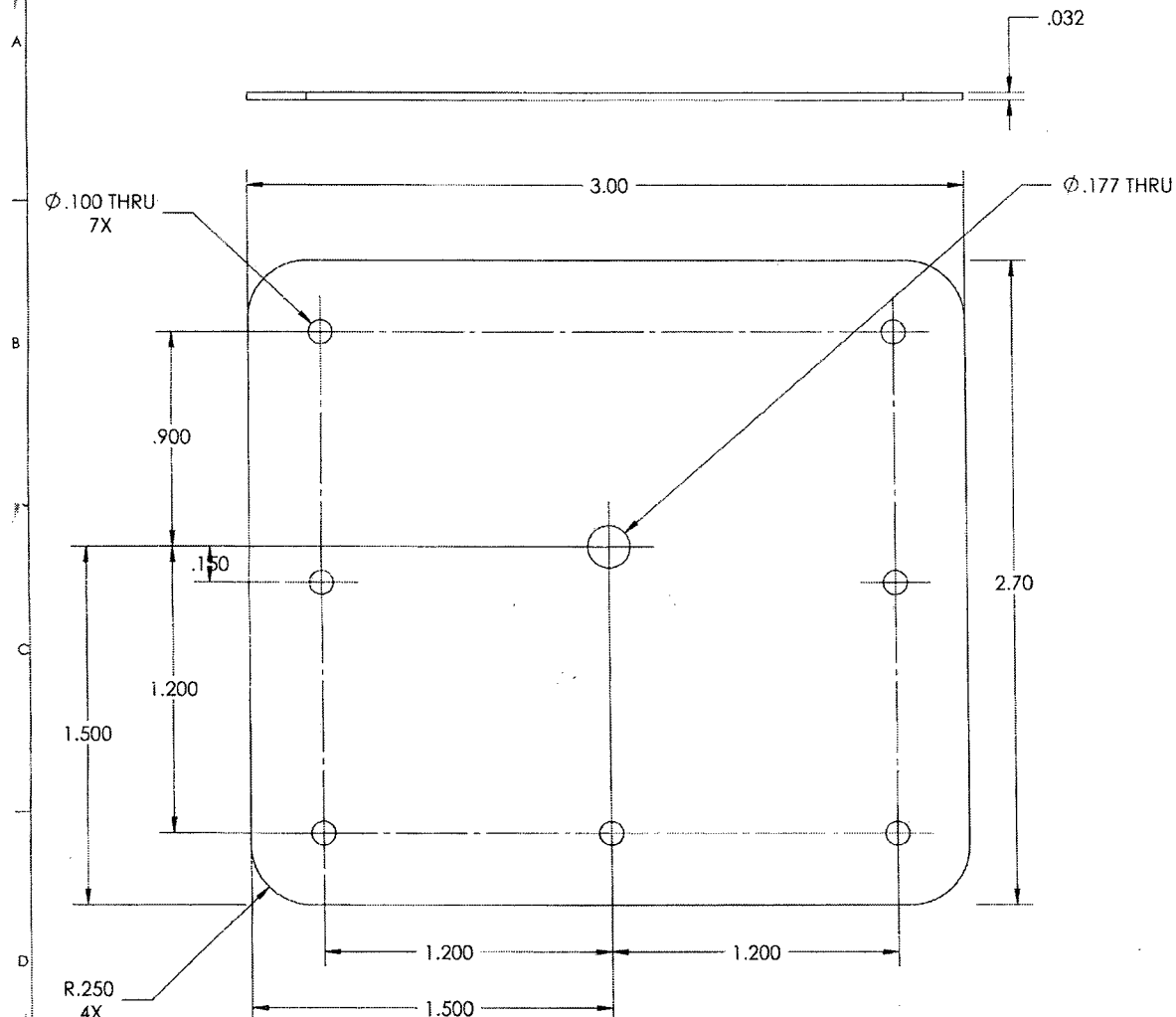


FLAT PATTERN

ORIGINAL DATE 2/20/04 10:00		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300	
DRAWN BY P. POSANO	CHECKED P. BRAVO	SHEETMETAL	
DRAWING APPROVAL P. BRAVO	DATE 10/20/04	REV. A	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DIMENSIONS ± .01 3 PLACE DIMENSIONS ± .005 ANGLES ± .5°		REV. CODE B 07M26	REV. A
SCALE NONE		SHEET 5 OF 6	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



59759

ORIGINAL DATE 05-28-04 DRAWN BY E. ROSANO CHECKED BY P. BRADY DRAWING APPROVAL P. BRADY 05-28-04 CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SEE CAD4 CODES B 07/12/16	DWG. NO. 647.0100
SCALE NONE		SHEET	6 OF 6



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62691

Date: 18-Oct-13

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To


DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST Rev: 11 PCS 647.0114 (7.95\$EA) 10 PCS 647.0115 (7.95\$EA) 10 PCS 647.9613 (16.30\$EA) HARD BLACK ANODIZE MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130649 PO: 21431 Line:		
<p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE: <u>18/10/13</u></p> <p>CERTIFIED SIGNATURE: <u></u></p> <p>RECEIVER SIGNATURE: _____</p>			